

इंटरनेट

मानक

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“जानने का अधिकार, जीने का अधिकार”

Mazdoor Kisan Shakti Sangathan

“The Right to Information, The Right to Live”

“पुराने को छोड़ नये के तरफ”

Jawaharlal Nehru

“Step Out From the Old to the New”

IS 11949 (1987): Turret Sockets [PGD 32: Cutting tools]



“ज्ञान से एक नये भारत का निर्माण”

Satyanarayan Gangaram Pitroda

“Invent a New India Using Knowledge”



“ज्ञान एक ऐसा खजाना है जो कभी चुराया नहीं जा सकता है”

Bhartrhari—Nitiśatakam

“Knowledge is such a treasure which cannot be stolen”

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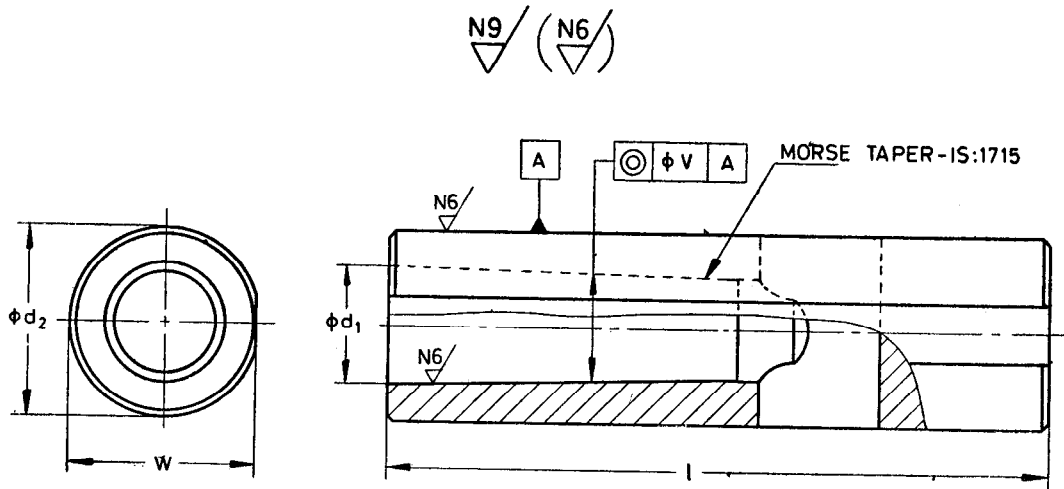
Small Tools Sectional Committee, EDC 45; Twist Drills, Reamers, Countersink and Counterbores Subcommittee, EDC 45 : 1 [Ref: Doc: EDC 45 (4194)]

Indian Standard

SPECIFICATION FOR
TURRET SOCKETS

1. Scope — Covers dimensions and requirements of turret sockets suitable for tools with morse taper shanks having tang end.

2. Dimensions



All dimensions in millimetres.

Morse Taper No.	Gauge Plane Diameter d_1	Outside Diameter d_2 g^+	Overall Length l	W	V Max
1	12.065	16	80	15.3	0.015
		20	90	19.0	
		25	95	24.3	
		30	115	29.0	
2	17.780	25	95	24.3	0.015
		30	115	29.0	
		40	135	39.3	
3	23.825	30	115	29.0	0.015
		40	135	39.3	
		50	175	49.2	
4	31.267	40	135	39.3	0.015
		50	175	49.2	
5	44.399	50	175	49.2	0.020

Note 1 — Dimensions for untoleranced dimensions 'medium class according to IS : 2102 (Part 1)-1980 General tolerances for dimensions and form and position: Part 1 General tolerances for linear and angular dimensions (second revision)'.

Note 2 — Length of flat position may be provided as agreed to between manufacturer and purchaser.

Adopted 30 January 1987

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3. Material — Case hardening steel of tensile strength not less than 600 MPa in the core after case hardening.

4. Hardness — Shall be case hardened to 590 to 670 HV.

5. Designation — A turret socket having inside morse taper No. 2, outside diameter (d_2) = 30 shall be designated as:

Turret Socket M T 2 × 30 IS : 11949

6. General Requirements — Dimensions for morse taper shall be according to IS : 1715-1986 'Dimensions for self-holding tapers (*second revision*)'.

7. Finish — The turret sockets shall be free from cracks, burrs, pits and other defects.

8. Preservation and Packing

8.1 A suitable anti-corrosive surface treatment shall be given to turret sockets.

8.2 Turret sockets shall be packed in suitable cartons so as to protect from damages.

9. Marking

9.1 The turret sockets shall be marked with the designation and name of the manufacturer or trade-mark.

9.2 Certification Marking — Details available with the Bureau of Indian Standards.

EXPLANATORY NOTE

In the preparation of this standard, considerable assistance has been derived from BS 1660-1972 'Machine tapers, reduction sleeves and extension sockets' issued by the British Standards Institution (BSI).